

Work Order ID 56576

Monday, March 01, 2010 3:01:45 PM

Page 1

Item ID: D2938-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle RH Out, 206

Start Date: 3/2/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *10-3-1* Tooling:

Date:

Run Start

QC: Date: SPC (Y/N):

Date:

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2938 | Rev C |

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

DJP
*10/03/06**6* *0*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

DJP
*10/03/07**6* *0*

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

DJP
*10/03/07**6* *0*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 56576

Page 2

Monday, March 01, 2010 3:01:45 PM

Item ID: D2938-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 3/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

ME

10/03/09

6

8

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

274

10/03/10

X6

6

Memo

0.00

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

274

10/03/10

X6

6

Memo

0.00

START TIME:

10:30AM

OVEN TEMPERATURE:

FINISH TIME:

320°F

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 56576

Page 3

Monday, March 01, 2010 3:01:45 PM

Item ID: D2938-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 3/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-3-10. (6) 0

170

Identify as per dwg & Stock Location: 428A

0.00



Packaging

Memo

0.00

Packaging

10/03/11 (6)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11 (6)

MF

10-3-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Monday, March 01, 2010 3:01:44 PM

Work Order ID: 56576



Parent Item: D2938-2



Parent Item Name: Saddle RH Out, 206

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D6101-003 | | Manufactured | No | | | 100 | Each | 34.0000 | 6.0000 | | | |



Saddle Billet, 7075



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

46410

34

34

MNF
12/03/09

6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|------------------------------------------------------|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 56578 |
| Description: 206 Saddle, Outboard, Right side | | Part Number: D2938-2 |
| Inspection Dwg: D2938 Rev. C | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|---|---|----|------|
| Dim | Min | Max | Go/No Go Gauge | 5 | 6 | 7 | 4 | | |
| A | 0.100 | 0.140 | | 0.106 | 0.105 | | | | |
| B | 0.100 | 0.140 | | 0.107 | 0.106 | | | | |
| C | 0.100 | 0.140 | | 0.120 | 0.119 | | | | |
| D | 0.210 | 0.230 | | 0.225 | 0.225 | | | | |
| E | 1.245 | 1.255 | | 1.250 | 1.250 | | | | |
| F | 1.245 | 1.255 | | 1.250 | 1.250 | | | | |
| G | 2.495 | 2.505 | | 2.500 | 2.500 | | | | |
| H | 0.510 | 0.515 | | 0.511 | 0.511 | | | | |
| I | 1.572 | 1.582 | | 1.577 | 1.577 | | | | |
| J | 2.495 | 2.505 | | 2.500 | 2.500 | | | | |
| K | 0.257 | 0.262 | | 0.259 | 0.259 | | | | |
| L | 0.312 | 0.317 | | 0.314 | 0.314 | | | | |
| M | 0.235 | 0.240 | | .237 | .237 | | | | |
| N | 0.100 | 0.140 | | 0.119 | 0.119 | | | | |
| O | 0.540 | 0.560 | | 0.548 | 0.548 | | | | |
| P | 0.490 | 0.510 | | 0.499 | 0.499 | | | | |
| Q | 3.715 | 3.725 | | 3.720 | 3.720 | | | | |
| R | 2.720 | 2.760 | | 2.739 | 2.740 | | | | |
| S | 0.240 | 0.270 | | 0.254 | 0.252 | | | | |
| T | 0.100 | 0.180 | | 0.130 | 0.130 | | | | |
| U | 1.625 | 1.635 | | 1.627 | 1.627 | | | | |
| V | 1.362 | 1.372 | | 1.367 | 1.367 | | | | |
| W | 0.316 | 0.321 | | 0.317 | 0.317 | | | | |
| X | 1.250 | 1.270 | | 1.260 | 1.261 | | | | |
| Y | 1.565 | 1.585 | | 1.565 | 1.5665 | | | | |
| Z | 0.178 | 0.198 | | 0.188 | 0.188 | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

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|------------------|
| Measured by: DJP |
| Date: 10/03/07 |

| |
|----------------|
| Audited by: MW |
| Date: 10/03/07 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------------------------------------|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | |
| C | 07.03.21 | Revised per drawing revision C | KJ/JLM | |

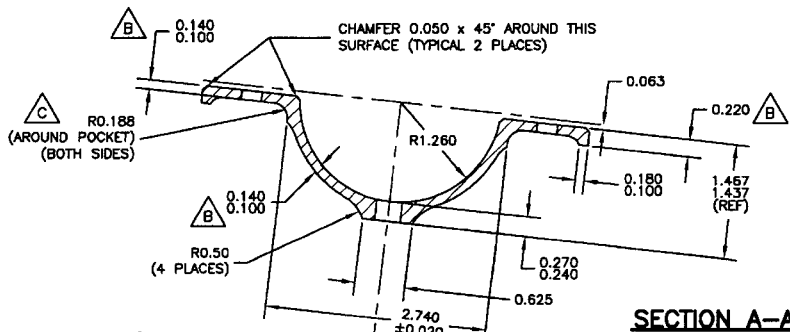
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

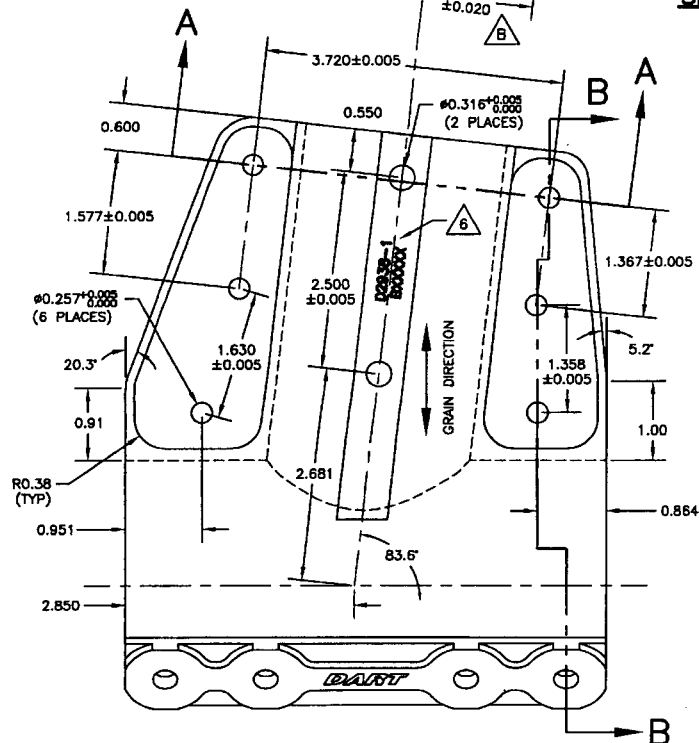
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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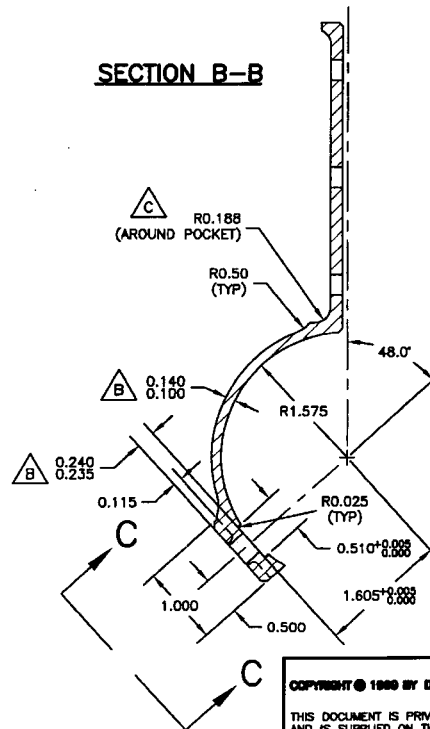
NOTE: Date & initial all entries



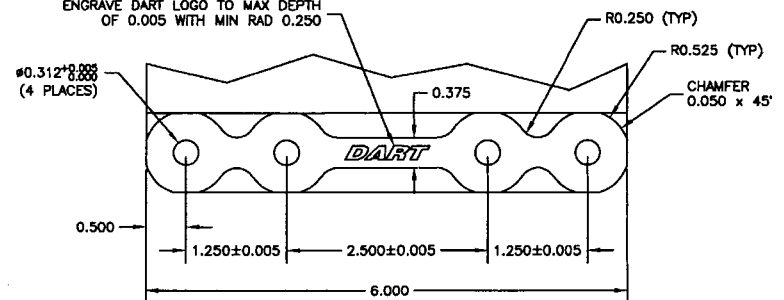
SECTION A-A



SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250



VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

| | | |
|---------|----------|-------------------------------------------------|
| C | 06.11.09 | R0.188 WAS R0.30 TO R0.25 |
| B | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A | 99.11.12 | NEW ISSUE |
| DESIGN | CB | DART DART AEROSPACE USA, INC. BELLINGHAM, WA |
| CHECKED | PH | DRAWING NO. D2938 |
| DATE | 06.11.09 | TITLE SADDLE OUTSIDE |
| | | REV. C SHEET 1 OF 1 SCALE 2:3 |

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07.02.12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | |
|------------------------------------------------------|-----------------------------|
| DART AEROSPACE LTD | Work Order: 56576 |
| Description: 206 Saddle, Outboard, Right side | Part Number: D2938-2 |
| Inspection Dwg: D2938 Rev. C | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.100 | 0.140 | | 0.102 | 0.104 | 0.104 | 0.104 | | |
| B | 0.100 | 0.140 | | 0.102 | 0.104 | 0.104 | 0.104 | | |
| C | 0.100 | 0.140 | | 0.118 | 0.120 | 0.120 | 0.120 | | |
| D | 0.210 | 0.230 | | 0.224 | 0.225 | 0.2235 | 0.2245 | | |
| E | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| F | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| G | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| H | 0.510 | 0.515 | | 0.511 | 0.511 | 0.511 | 0.511 | | |
| I | 1.572 | 1.582 | | 1.577 | 1.577 | 1.577 | 1.577 | | |
| J | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| K | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | 0.259 | | |
| L | 0.312 | 0.317 | | 0.317 | 0.314 | 0.314 | 0.314 | | |
| M | 0.235 | 0.240 | | 0.237 | 0.237 | 0.237 | 0.237 | | |
| N | 0.100 | 0.140 | | 0.126 | 0.120 | 0.118 | 0.1185 | | |
| O | 0.540 | 0.560 | | 0.548 | 0.497 | 0.497 | 0.498 | | |
| P | 0.490 | 0.510 | | 0.5015 | 0.497 | 0.497 | 0.497 | | |
| Q | 3.715 | 3.725 | | 3.720 | 3.720 | 3.720 | 3.720 | | |
| R | 2.720 | 2.760 | | 2.738 | 2.738 | 2.738 | 2.738 | | |
| S | 0.240 | 0.270 | | 0.250 | 0.250 | 0.250 | 0.251 | | |
| T | 0.100 | 0.180 | | 0.130 | 0.130 | 0.130 | 0.130 | | |
| U | 1.625 | 1.635 | | 1.630 | 1.630 | 1.630 | 1.630 | | |
| V | 1.362 | 1.372 | | 1.367 | 1.367 | 1.367 | 1.367 | | |
| W | 0.316 | 0.321 | | 0.317 | 0.317 | 0.317 | 0.317 | | |
| X | 1.250 | 1.270 | | 1.2655 | 1.2625 | 1.2610 | 1.261 | | |
| Y | 1.565 | 1.585 | | 1.5715 | 1.5695 | 1.5645 | 1.566 | | |
| Z | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

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|------------------|
| Measured by: DJP |
| Date: 10/03/06 |

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|-----------------|
| Audited by: MJF |
| Date: 10/03/09 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------------------------------------------|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | |
| C | 07.03.21 | Revised per drawing revision C | KJ/JLM | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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